

CLAIMS

- [001] A refrigerating unit comprising a suction tube (2) and a throttling tube (1) which runs at least over a part of its length inside the suction tube (2) and is guided out from the suction tube (2) to form a first outlet location (A), wherein the throttling tube (1) and the suction tube (2) are joined to one another at a second location (B) of the suction tube (2) at which outer surfaces of the throttling tube (1) and the suction tube (2) are in contact, characterised in that the outer surfaces of the throttling tube (1) and the suction tube (2) are joined to one another at the second location (B) by ultrasound welding.
- [002] The refrigerating unit according to claim 1, characterised in that the second location (B) is about 5 mm to 20 mm, preferably about 10 mm from the first location (A).
- [003] The refrigerating unit according to claim 1 or claim 2, characterised in that the second location (B) is located downstream from the outlet location (A) with reference to the refrigerant flowing in the suction tube (2).
- [004] The refrigerating unit according to any one of claims 1 to 3, characterised in that the outlet location (A) is provided at a connecting tube (11) on which both the suction tube (2) and the throttling tube (1) are fixed downstream in a liquid- and gastight manner.
- [005] The refrigerating unit according to any one of claims 1 to 3, characterised in that the suction tube (2) has an expansion or a cut for the throttling tube (1) in the area of the outlet location (A).
- [006] A method for joining a suction tube (2) of a refrigerating unit to a throttling tube (1) comprising the following steps: guiding the throttling tube (1) out

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from the inside of the suction (2) at an outlet location (A) of the suction tube (2);

joining the suction tube (2) and the throttling tube (1) at the outlet location (A), especially by soldering;

bringing in contact an outer surface of a portion of the throttling tube (1) located outside the suction tube (2) with an outer surface of the suction tube (2) at a second location (B) of the suction tube (2);

joining the suction tube (2) and the throttling tube (1) at the second location (B); characterised in that the outer surfaces of the suction tube (2) and the throttling tube (1) are joined to one another at the second location (B) by ultrasound welding.